

Work Order ID 67721

Tuesday, March 29, 2011 2:25:44 PM



Page 1

Item ID: D4006-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Top Support Assembly

3

Start Date: 3/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: 11/03/30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4006	A

100

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

11/06/02 (3)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/06/02

(3)

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

Start Time:

Oven Temperature:

Finish Time:

7=30
32001
8=00

0.00

Powder Coating

3x 11/06/06

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 BR 11-6-6

140

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Apply glue and install Foam as per dwg
Batch: M111095
2- Install anchor nuts as per dwg

3M 1300 contact cement

EP 4/06/06 (3)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u 6/06

(43)

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Run Start



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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 107

0.00



Packaging

Memo

0.00

Packaging

11/6/06

38

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/06

MF
11-06-06

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Picklist Print

Tuesday, March 29, 2011 2:25:51 PM

Page 1

Work Order ID: 67721

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly



Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD
10.05.03 as per ECN10-562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM
IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 		Manufactured	No			100	Each	0.0000	1	2			
Angle						B70187		(34)				ES 11/06/02	
D4006-3 		Manufactured	No			100	Each	0.0000	2	4			
Channel						B68383		(B)				ES 11/06/02	
MS20470AD4-5 		Purchased	No			100	Each	2,028.000	8	16			
Rivet, Universal Head												ES 11/06/02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		2028							
				116410		353							
				116893		1675							
D4006-5 		Manufactured	No			140	Each	16.0000	1	2			
Foam												ES 11/06/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST107		16							
				63940		16							
MS20426AD3-4 		Purchased	No			140	Each	5,274.000	4	8			
RIVET												ES 11/06/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		5274							
				104374		1274							
				110398		4000							

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Picklist Print

Tuesday, March 29, 2011 2:25:51 PM

Page 2

Work Order ID: 67721



Parent Item: D4006-041



Parent Item Name: Tank Top Support Assembly

Start Date: 3/29/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

MS21059L4

Purchased

No

140

Each

46.0000

2

4



Nutplate

Location

Loc Qty

Loc Code

ST302

46

116582

46

EB 11/06/06
M117887

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

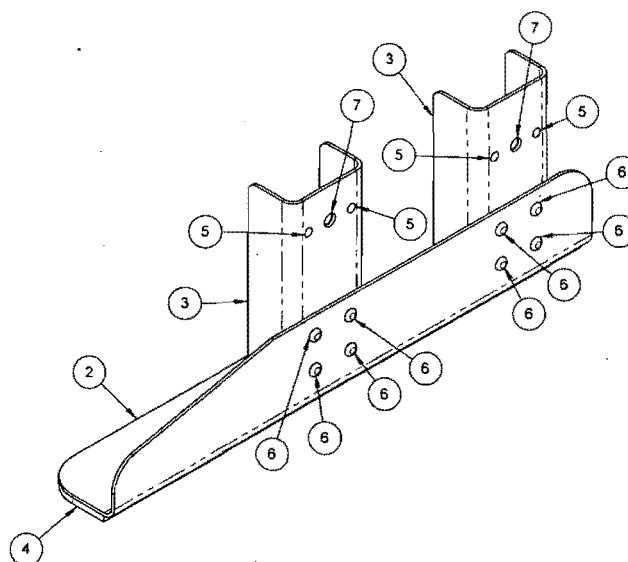
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67721

11-03-30

RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE	BY <i>MP</i>	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>MP</i>		
DRAWN	<i>MP</i>		
CHECKED	<i>MP</i>		
MFG. APPR.	<i>MP</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4006	REV. A
TITLE UPPER RESTRAINT	SCALE NTS
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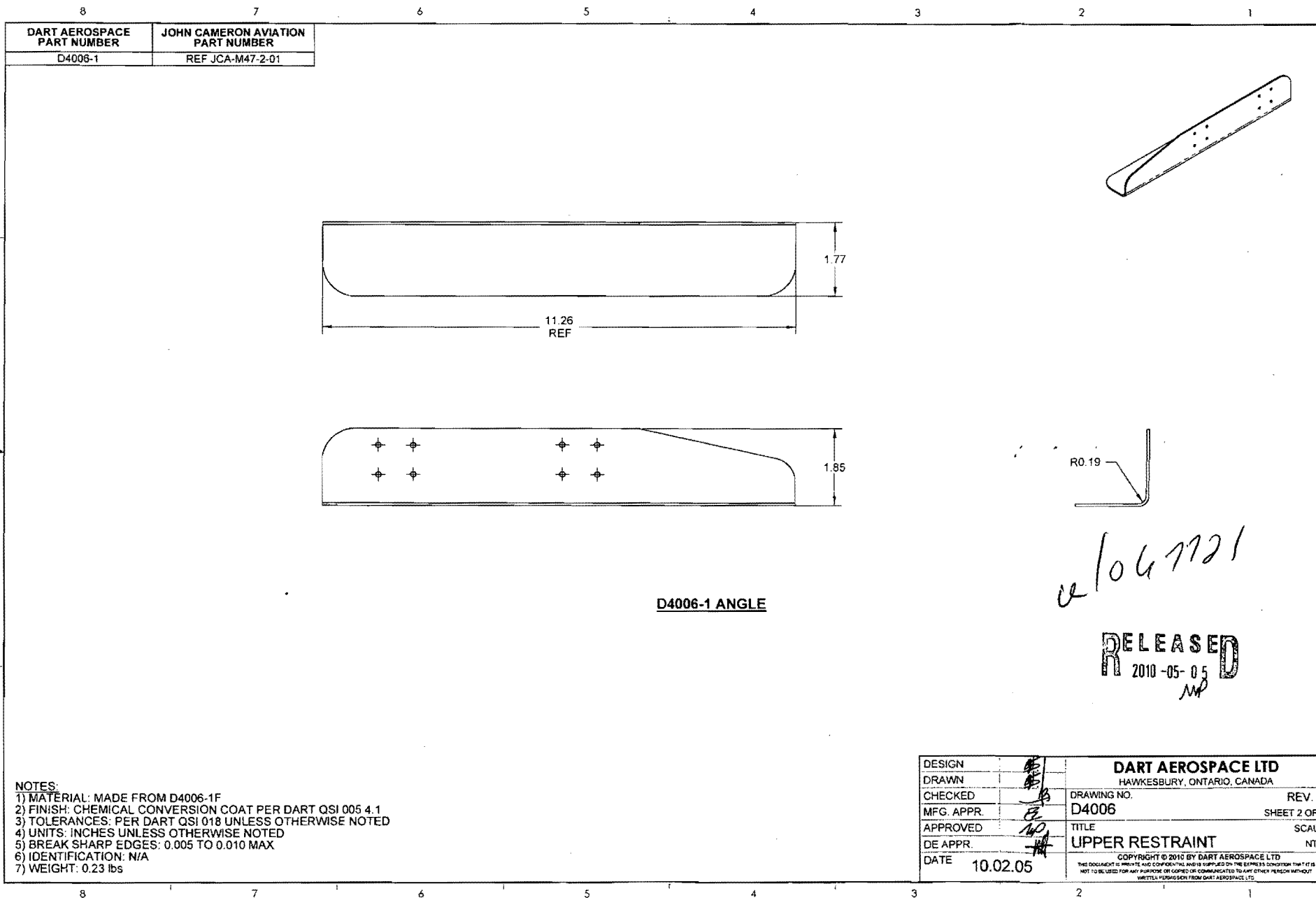
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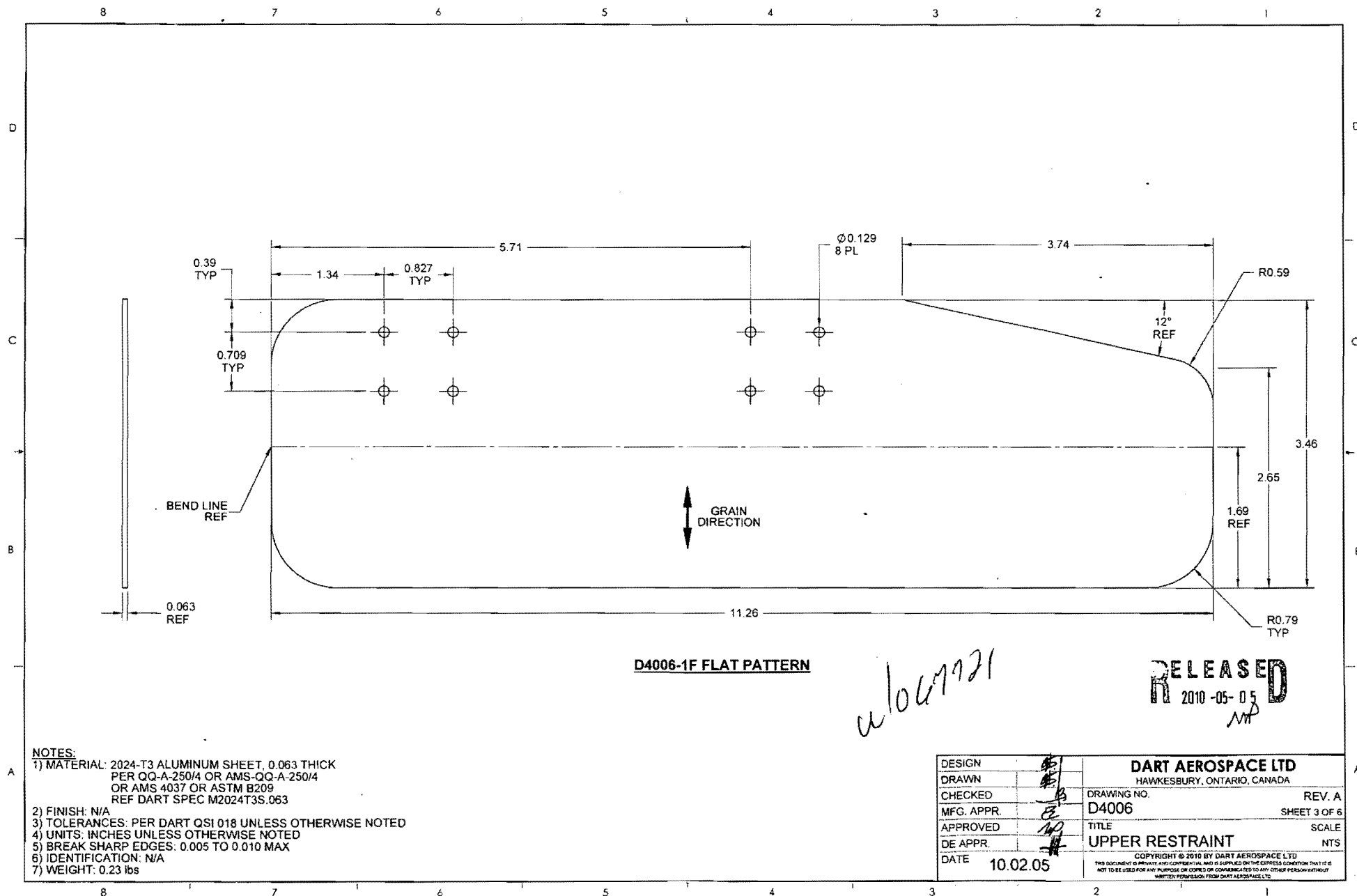
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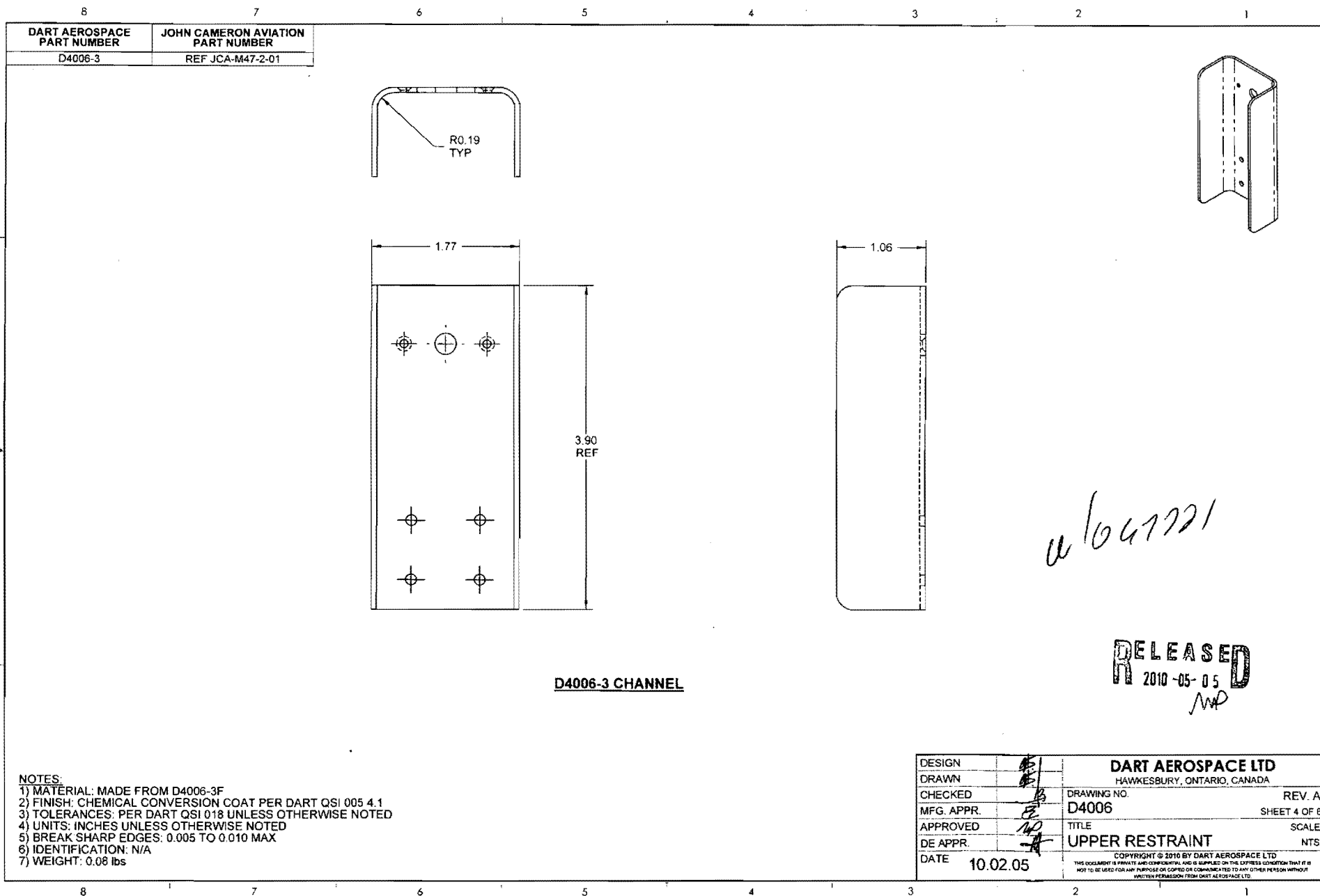
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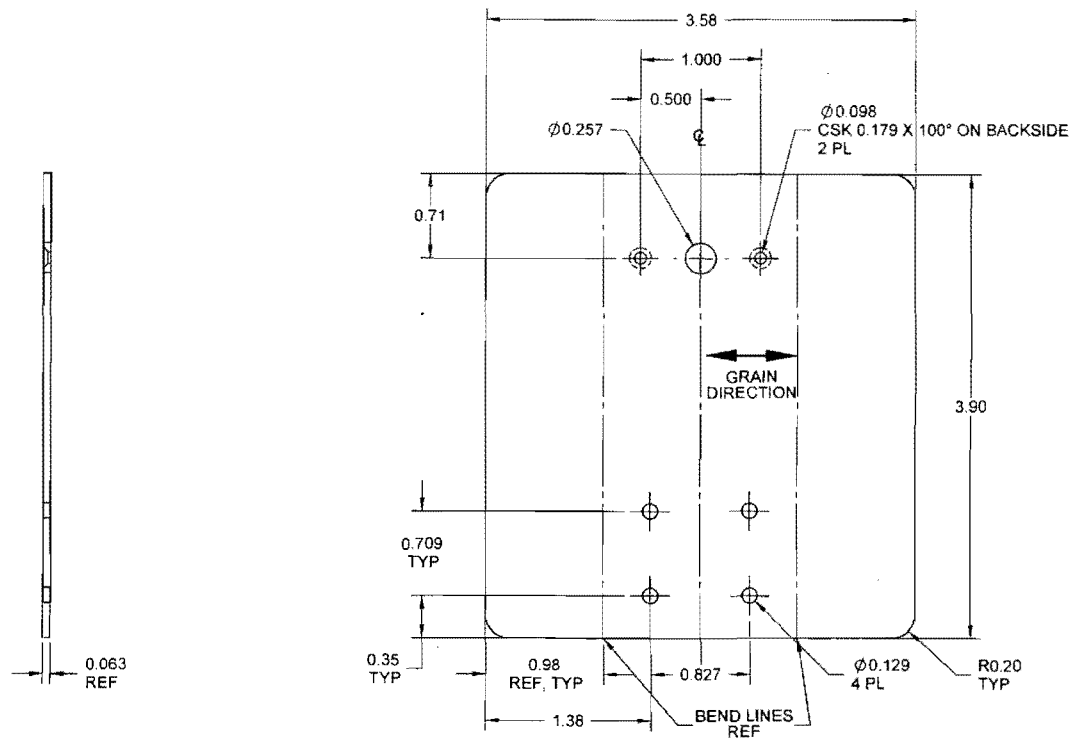
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D4006-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		UPPER RESTRAINT	
DATE	10.02.05	NTS	

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WLO 67721

RELEASED
2010-05-05
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

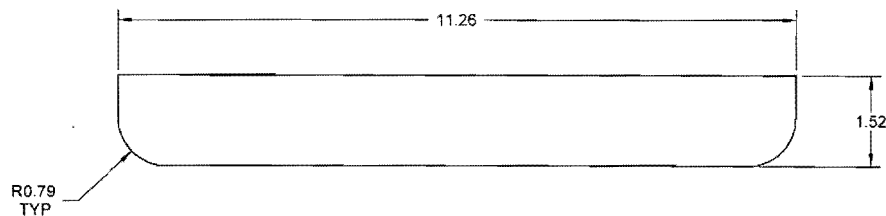
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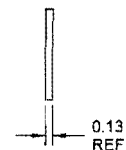
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



D4006-5 FOAM



w/097221

RELEASED
2010-05-05
MD

- NOTES:
- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4006	SHEET 6 OF 6
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DE APPR.		UPPER RESTRAINT	NTS
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